












Date: Tuesday, 30/09/2008 8:54:13 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: CAP
<b>Job Number</b>	: 42343		
<b>Estimate Number</b>	: 10519		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2855
<b>This Issue</b>	: 30/09/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2855 REV. A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 41340	<b>Drawing Revision</b>	: A
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JD 08.9.30</u>	<b>Due Date</b>	: 10/10/2008
<b>Comment</b>	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	PG	PURCHASING	
			
<b>Comment:</b> PURCHASING Issue P/O: <u>7278</u> Cast per Dwg D2855 Material Release Note Required <i>CL 08/09/30</i> <i>(50)</i>			
2.0	D2855P	Cap	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s) CAP			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
<b>Comment:</b> PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>P 8/11/09</i> <i>(50)</i>			
4.0	QC6	DIMENSIONAL CHECK	
			
<b>Comment:</b> DIMENSIONAL CHECK <i>508/11/09</i> <i>(50)</i> <i>counters</i>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr <i>CL 08/11/10</i> <i>(50)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: CAP

Job Number: 42343

Part Number: D2855

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

808/10/10

(50)

7.0

POWDER COATING

POWDER COATING



M109152



(50X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:30

OVEN TEMPERATURE:

320°C

FINISH TIME:

12:00

M/L 08/11/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(50)

Comment: INSPECT POWDER COAT

FZ 08/11/10

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M100621

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

\*

FZ

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(50)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

FZ 08/11/11

11.0

QC5

INSPECT WORK TO CURRENT STEP



08/11/12 (50)

Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F15-7

MS

08.11.12

(X50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:13 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 42343

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/13 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

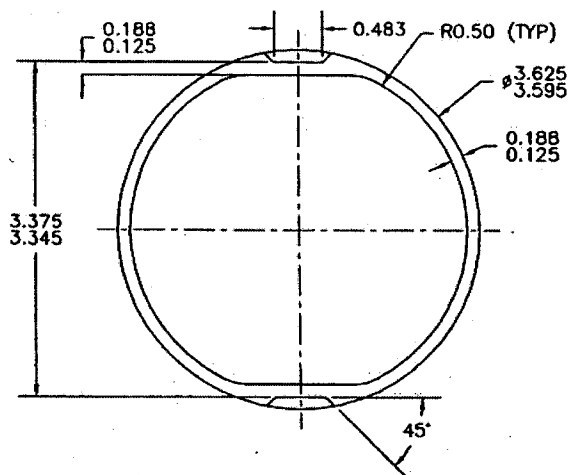
**NOTE:** Date & initial all entries



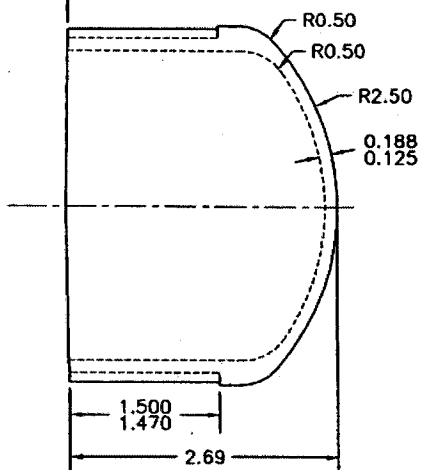
DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	D2855
DATE	98.12.12	TITLE	CAP
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	REV. A
			SHEET 1 OF 1
			SCALE
			NTS

RELEASED  
98.12.14 DS

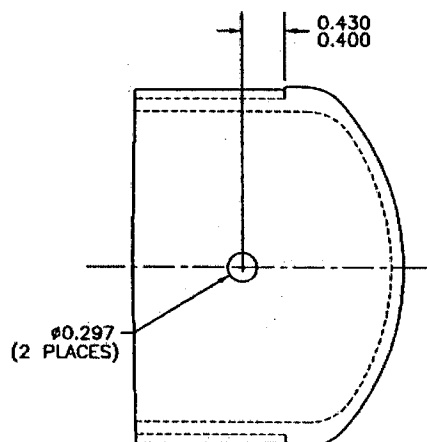
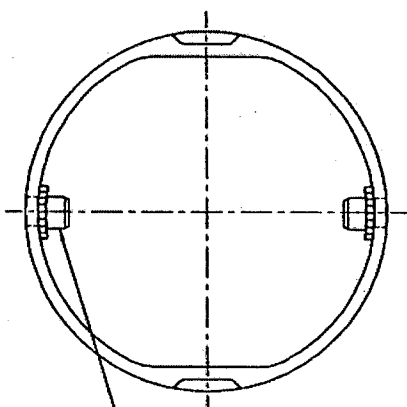
D2855 CASTING DETAIL



1° TAPER



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 43 KG 99.09.12  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 423475

# Aluminum Foundry Ltd

714-716 Calais  
Dorval, Québec H9P 2P3  
Tel: (514) 631-1331  
Fax: (514) 631-8448

## Packing Slip

Packing Slip No.: 32798  
Date: Oct 31, 2008  
Page: 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 7278	<b>Sold By:</b>
<b>Shipped By:</b>	<b>Ship Date:</b> Oct 31, 2008
<b>Tracking No.:</b>	

Item No	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	50
Comment:			

*Handwritten signature and date: C 8/11/03*



7 CERTIFICAT DE CONFORMITÉ  
 CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
 ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3  
 TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à  
 Shipped

DART AEROSPACE

1270 Aberdeen Street

Hawksbury, ON, K6A 1K7

A.F. & P.W. Série no./Serial no.

Date: 31/10/2008 Packing Slip No. 32798

Votre No. Commande 00007278  
 Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
50	D 2855 CAP	Z098046	A356.2  S exhibe	ingot#351118

Analyse  
 Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne  
 Yield :

Résistance à la tension :  
 Tensile Strength :

Allongement par pouce carré :  
 P.S.I. Elongation :

%

Pour et au nom de  
 For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
 ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :  
 Par/Per :

Coc-100